

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024052**Date Inspected:** 08-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 1

This QA inspector observed ZPMC in process of heat straightening on Bike Path Handrail Assembly. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Huang Min as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10267

BKR-NS-3

Bay 5

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening on traveler rail assembly. ZPMC CWI Huang Min was present at this time of this observation and informed this QA inspector of the work that is in process. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10291

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3025TR1-001-001~011

Bay 9

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of heat straightening on traveler rail assembly. ZPMC QC inspector Zhu Zhang Jie was present at this time of this observation and informed this QA inspector of the work that is in process and identified Chen Shi Gang as the CWI. This QA inspector verified this information for the following location;

Heat Straightening

HSR1 (B) 10240

3016TR1-001-002

Bay 11

VT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09069 Item 1 (TC-RFI-0369R0) on Tower Boom-Hollow Section, identified TBSA7-3 (ESD1 & NSD1) assemblies. The rework was verified for the addition cope hole cover plates, cover plate seal weld and workmanship. ZPMC CWI Yu Dong Ping was present at this time of this observation. The rework appeared to be in general conformance with TC-RFI-0369R0 requirements.

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents.

This QA inspector performed a random observation for the Tower. During the observation performed it was noted ZPMC was in process of welding on tower subassembly. ZPMC QC inspector Wang Chuang Xin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 1 welder tack welding and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- ESD1-TBSA7-4B/B-012

WPS-B-P-2112

Welder- 202319

2F/SMAW/ PL7-13

Bay 8

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09067 Item 1, 2, 3 on OBG assemblies, identified as SB3001A-001, LB3001A-001 and LB3100A in Bay 8. This QA Inspector performed verification Magnetic Particle Testing (MT) inspection after ZPMC had performed their MT inspection of the following locations;

LB3001A-001-002~005, 007~010, LB3100A-001-002~005, 007~010 and SB3001A-001-002~005, 007~010

See Caltrans Magnetic Particle Test Report (TL6028), dated 05-08-2011 for additional information. However,

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ZPMC inspector Cui Jun Jie canceled QAMT inspection for weld 006 call-out on NWIT 09067 for Item 1, 2, 3.
ZPMC QC stated that there was no such weld in the weld sequence.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike
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Quality Assurance Inspector

Reviewed By:	Riley, Ken
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QA Reviewer
